

Work Order ID 122787

July-25-14 9:53:36 AM

122787

Page 1

Item ID: D4974-1

Revision ID:

Item Name: Upper Rail

Start Date: 7/25/14 Start Qty: 4.00

Required Date: 7/25/14 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MLS

QC:

Date: 14-07-25

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4974

D

105

0.00

105

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 12.875" LONG

0.00

110

0.00

110

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB230

DWG REV: D

FOLIO REV: AA

0.00

2- deburr and break all sharp edges

4

SL 14-7-25

4

Ø

DAS
20
9-89

14-07-26

Work Order ID 122787

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122787

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Item ID: D4974-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Rail

Start Date: 7/25/14 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 4.00 *4*

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 1408-12

MLJ 1408-12

Picklist Print

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Work Order ID: 122787

122787

Parent Item: D4974-1

D4974-1

Parent Item Name: Upper Rail

Start Date: 7/25/14

Required Date: 7/25/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 13-11-14 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.750X02.25 0		Purchased			No		f	20.8170		5			

M7075T6B1 750X02 250

7075-T6 BAR 1.750" X 2.250"

**

SL14-7-25

Location

Loc Qty

Loc Code

MAT001

20.817

123418

0.5

M128502

8.317

M129237

12

4.3

DART AEROSPACE LTD		Work Order: 122787
Description: UPPER RAIL		Part Number: 049741
Inspection Dwg: D4974 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

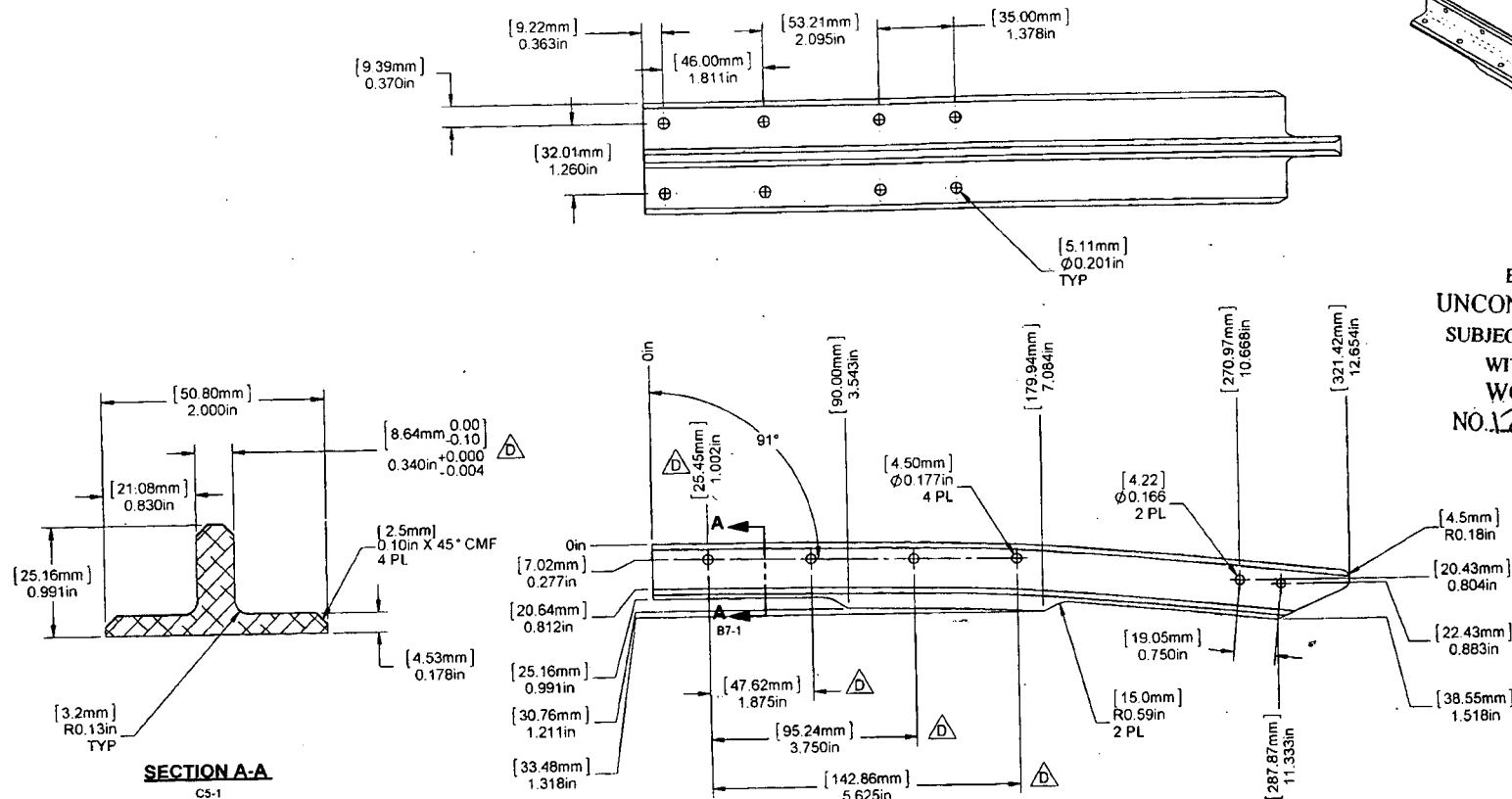
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
✓ .363	+/- .010	.3615	✓		SLO8	Vecm
✓ .370	+/- .010	.365	✓			
✓ 1.260	+/- .005	1.260	✓			
✓ 1.811	+/- .005	1.811	✓			
✓ 2.095	+/- .005	2.094	✓			
✓ 1.378	+/- .005	1.376	✓			
✓ φ .201	+ .005 / - .001	.201	✓			
✓ 2.000	+/- .010	1.998	✓			
✓ .830	+/- .010	.830	✓			
✓ .991	+/- .010	.990	✓			
✓ R.13	+/- .030	.125	✓			
✓ .178	+/- .010	.177	✓			
✓ .10 X 45°	+/- .030 X .5°	.100 X 45°	✓			
✓ .340	+0.000 / - .004	.338	✓		SLO2	Mic ✓
✓ 1.000	+/- .010	.999	✓			
✓ φ .177	+ .005 / - .001	.178	✓			
✓ φ .166	+ .005 / - .001	.165	✓			
✓ .277	+/- .010	.281	✓			
✓ 1.875	+/- .005	1.875	✓			
✓ 3.750	+/- .005	3.750	✓			
✓ 5.625	+/- .005	5.625	✓			
✓ .750	+/- .005	.750	✓			

Measured by: DAE 20 9-8	Audited by: DAE 08 9-89	Preliminary Approval:
Date: 14-07-20	Date: 14/07/21	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122784 MJS
1407-25



NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P-23377 TYPE I CLASS N: 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4974-1", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 0.89 lbs (0.41 kgs)
- 8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4974-1-d.IGES

D	REVISED UPPER RAIL HOLE LOCATIONS (ZN B5-1)	AK	14.07.18
C	REVISED DIMENSION TOLERANCE (ZN C6-1)	AK	14.06.05
B	REVISED NOTE 6) (ZN A8-1)	AK	14.05.07
A	ADDED HOLES TO D4974-1 (ZN D4-1)	DC	13.11.11
A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4974	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	UPPER RAIL	NTS
DATE	14.07.18	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR DOCUMENTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63197

Date: 08-Aug-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	Line:
4 ea	Part: D4974-1 UPPER RAIL HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140485 PO: PO25229		
4 ea	Part: D4973-1 UPPER CUTTER DEFLECTOR HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140486 PO: PO25229		
4 ea	Part: D5140-1 UPPER CUTTER HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140487 PO: PO25229		
4 ea	Part: DS140-2 UPPER CUTTER HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140488 PO: PO25229		
Certificate of Conformance			
A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.			
ISO 9001 : 2008 REGISTERED			



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Pack List

Number: 63197

Date: 08-Aug-14

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DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
ATG SALES-2010 TERMS APPLY		
DATE: <u>8/8/14</u>		
CERTIFIED SIGNATURE: <u></u>		
RECEIVER SIGNATURE: _____		